Work Order ID 58678

Monday, May 17, 2010 11:14:31 AM

Item ID: D3916-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Light Rib

Start Date: 5/14/2010 **Start Qty:** ~~9.00~~ 6

Required Date: 5/20/2010 **Req'd Qty:** 9.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** M **Date:** 10-5-14 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3916	A								
100		0.00				6			
Large Fab									
Large Fab	**Memo**	0.00							
	1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9566 *** Make line at 9.00" annd use jig for other line*** 3- Trim access tube material to finish size as per dwg D3916 SAD 10-05-01					6			
110	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00 Solved 01				x6			
120	Identify as per dwg & Stock Location: WA	0.00							
Packaging									
Packaging	**Memo**	0.00 SAD 10-06-01							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 58678

Monday, May 17, 2010 11:14:31 AM

Item ID: D3916-5 **Accept**

Revision ID:

Item Name: Light Rib

Setup **Start** **Stop**

Start Date: 5/14/2010 **Start Qty:** 9.00

Required Date: 5/20/2010 **Req'd Qty:** 9.00

Cust Item ID:

Customer:

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/06/02 [signature]

M 10-6-01

(6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, May 17, 2010 11:14:37 AM

Work Order ID: 58678

Parent Item: D3916-5

Parent Item Name: Light Rib

Start Date: 5/14/2010 **Required Date:** 5/20/2010

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC

Start Qty: 9.00 **Required Qty:** 9.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased	No			100	f	28.6546	4.166	SAD	10-05-01	

Square Tubing

Location	Loc Qty	Loc Code	
MAT	13.6499		
114426	13.6499		4.3852
MAT018	15.0047		
114004	3.5		
114161	11.5047		

M 114867 → 21.9263

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

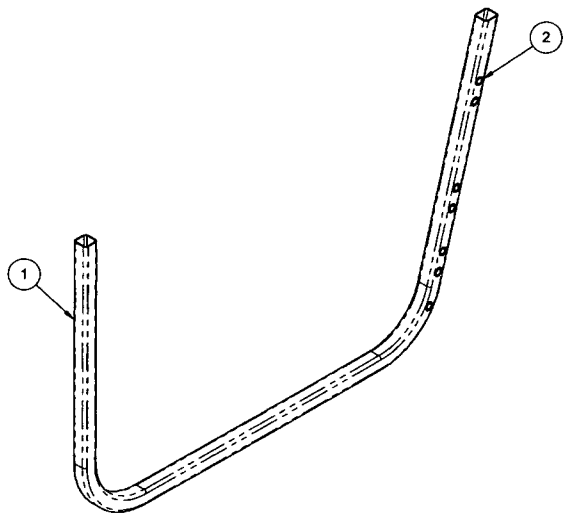
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

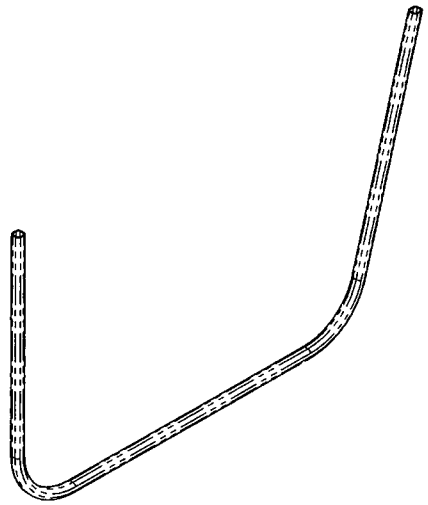
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58678

BJ 10-5-17



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

RELEASED
2010 -03- 12

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.03.04

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 REV. A
MFG. APPR.		SHEET 1 OF 4
APPROVED		TITLE RIB ASSY, 350 BASKET SCALE NTS
DE APPR.		
DATE	10.03.04	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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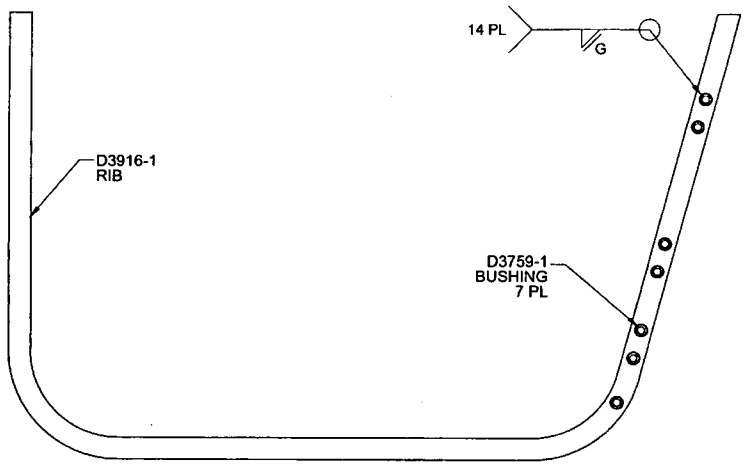
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D3916-041 RIB ASSY

W/O 58678

RELEASED
2010-03-12
MP

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT -041: 1.84 lbs
8) WELD PER DART QSI 004

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	JPH	
CHECKED		DRAWING NO. D3916 REV. A SHEET 2 OF 4
MFG. APPR.		
APPROVED		TITLE RIB ASSY, 350 BASKET SCALE NTS
DE APPR.		
DATE	10.03.04	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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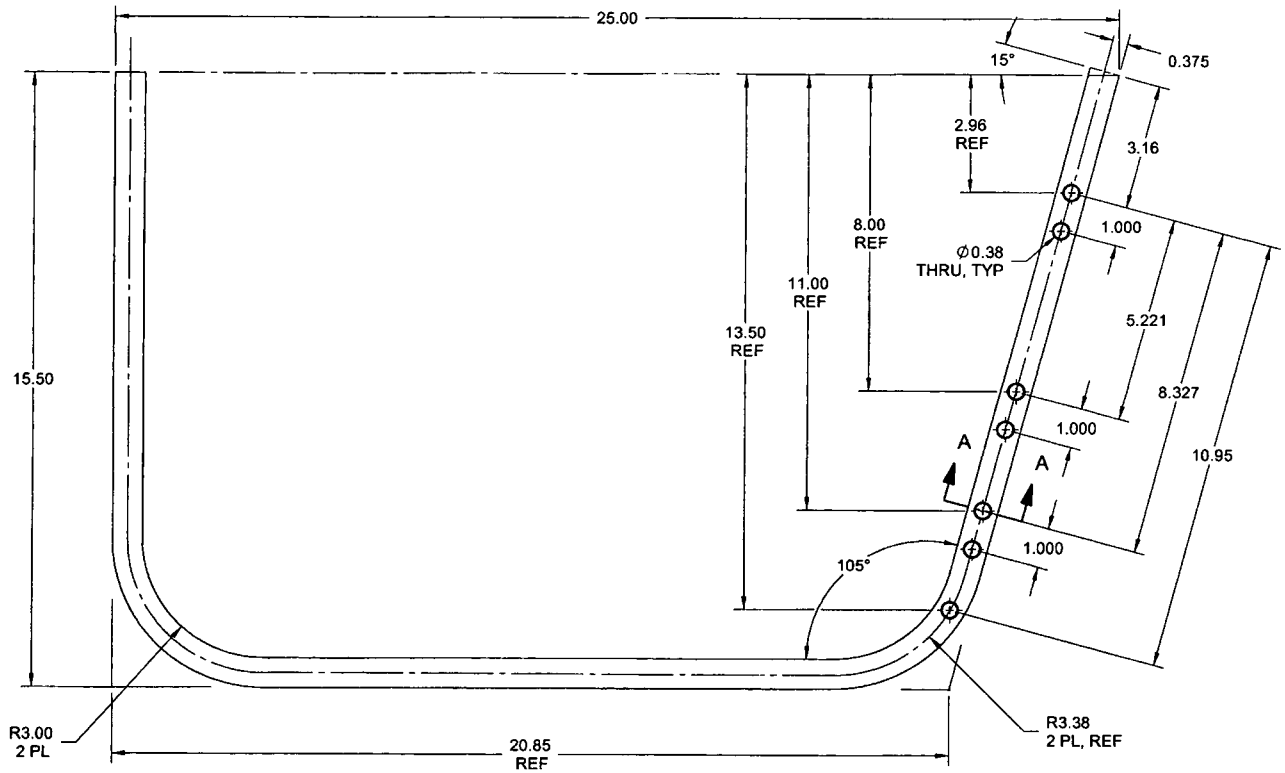
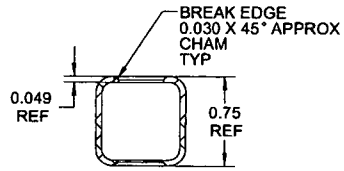
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



9 **D3916-1 RIB**



SECTION A-A

w/o 058678

RELEASED
2010 -03- 12
WAD

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.76 lbs
9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	**DART AEROSPACE LTD**
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3916 REV. A
MFG. APPR.		SHEET 3 OF 4
APPROVED		TITLE RIB ASSY, 350 BASKET SCALE NTS
DE APPR.		
DATE	10.03.04	

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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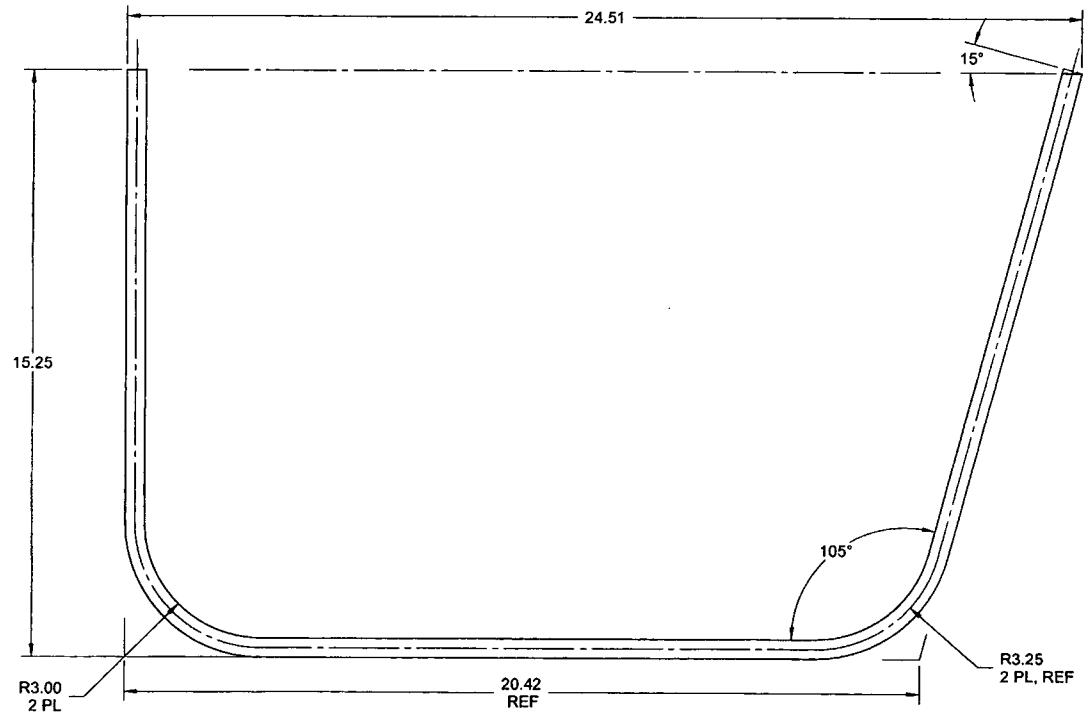

9 D3916-5 LIGHT RIB

w/o 58678

RELEASED
2010 -03- 12

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.07 lbs
9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3916 REV. A
MFG. APPR.		SHEET 4 OF 4
APPROVED		TITLE RIB ASSY, 350 BASKET SCALE NTS
DE APPR.		
DATE	10.03.04	

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Dart Aerospace Ltd

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